

Work Order ID 107832

October-03-13 11:37:12 AM

107832

Page 1

Item ID: D4074-1

D 4 0 7 4 - 1

Accept

N900040100

Setup

Start

NS1

Revision ID:

B 1 0 7 8 3 2

Stop

NS2

Item Name: Bracket

Start Date: 10/03/13 Start Qty: 16.00

16 *24*

Cust Item ID:

Required Date: 10/11/13 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
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D4074	C		0.00						
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100

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

24 0 Ae 13.10.05

24 0 Ae 13.10.05

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Item ID: D4074-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 10/03/13 Start Qty: 16.00

16

Cust Item ID:

Required Date: 10/11/13 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

DAS

27

9-89

B-10-7

24
Cans***120***

QC

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Brake NC

0.00

24

83
13/10/07

140

QC5- Inspect part completeness to step on W/O

0.00

DAS
27
9-89

B-10-7

140

QC

Quality Control

24
Cans

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Item ID: D4074-1 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Bracket Stop *NS2*

Start Date: 10/03/13 Start Qty: 16.00 *16* Cust Item ID:

Required Date: 10/11/13 Req'd Qty: 16.00 *16* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							24 13-10-8
	Memo	0.00							
160 *160* Powdercoat Powder Coating W126125	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							24 XPMY/13/10/09
	Memo	0.00							
	POWDER COAT: 10-20								
	Start Time: 3200								
	Oven Temperature: 3200								
	Finish Time: 10-55								
170 *170* QC Quality Control	QC3- Inspect Part Finish	0.00							24 13-10-4 D4074-1 QC Quality Control
	Memo	0.00							

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Item ID: D4074-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 10/03/13 Start Qty: 16.00

16

Cust Item ID:

Required Date: 10/11/13 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Packaging	Identify as per dwg & Stock Location: <u>ST091</u>	0.00							DAS 33 9-89 13-10-09
	Memo	0.00				24			
190 *190* QC	QC21- Final Inspection - Work Order Release	0.00							<u>PF</u> / <u>PL/3-10-10</u>
Quality Control	Memo	0.00							<u>ME</u> 13-10-09

Picklist Print

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Work Order ID: 107832

Start Date: 10/03/13

Required Date: 10/11/13

Parent Item: D4074-1

Start Qty: 16.00

Required Qty: 16.00

Parent Item Name: Bracket

Comments: IPP Rev:A 10.06.08, new issue DD verf:EC
11-07-25 JLM VERIFIED BY:EC

IPP REV:B AS PER ECN 11-613

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	120.4162	0.0452	1		Ae 13.10.05	

Location	Loc Qty	Loc Code
MAT021	120.4161578	
121473	0.9161578	
123279	72.89	
125257	6.1	
M126075	12.35	
<u>M126610</u>	28.16	

126610 → 1.5

DART AEROSPACE LTD	Work Order:	107852
Description: Bracket	Part Number:	D4074-1
Inspection Dwg: D4074	Rev: C	Page 1 of 1

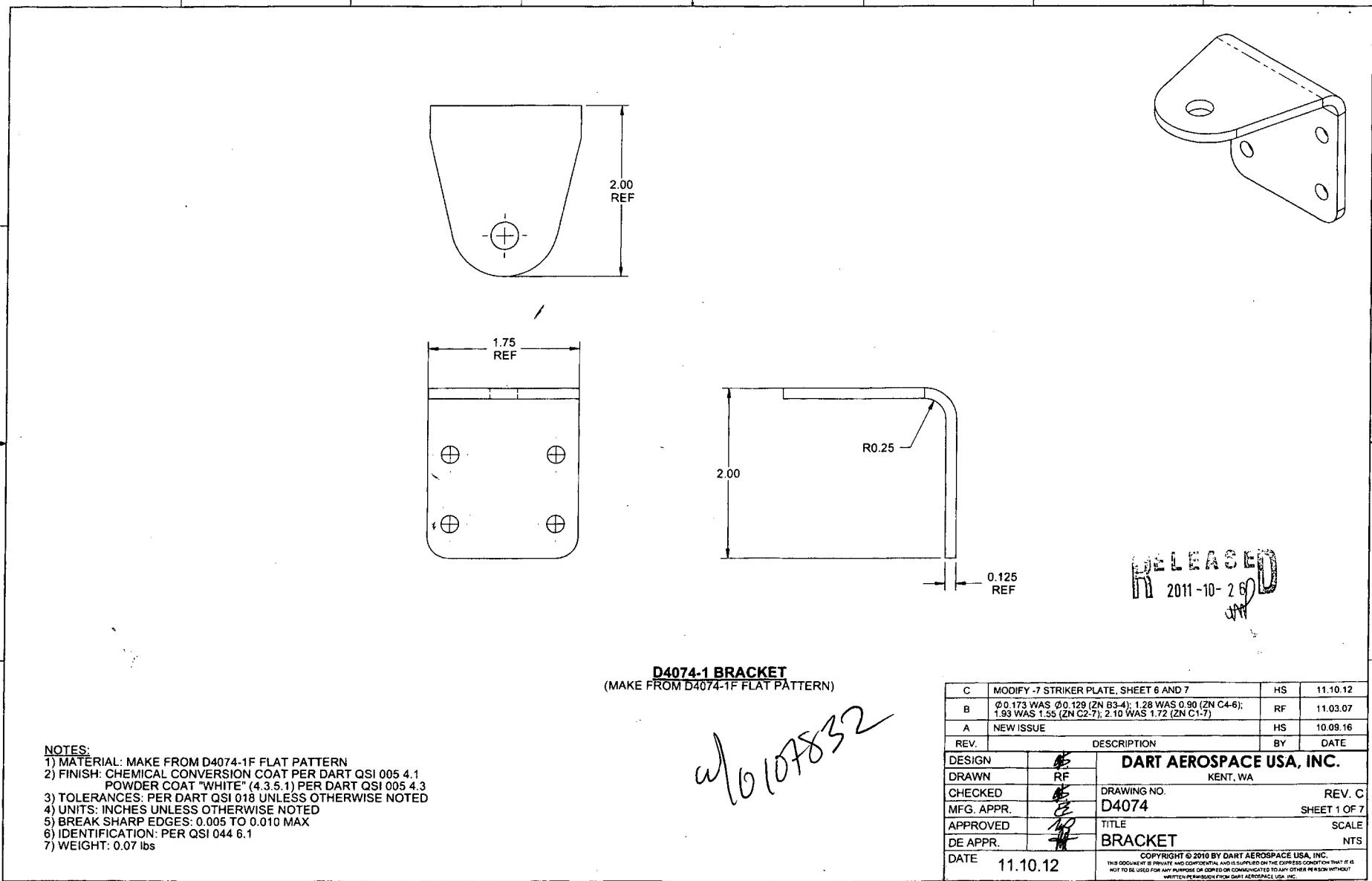
FIRST ARTICLE INSPECTION CHECKLIST

GAS

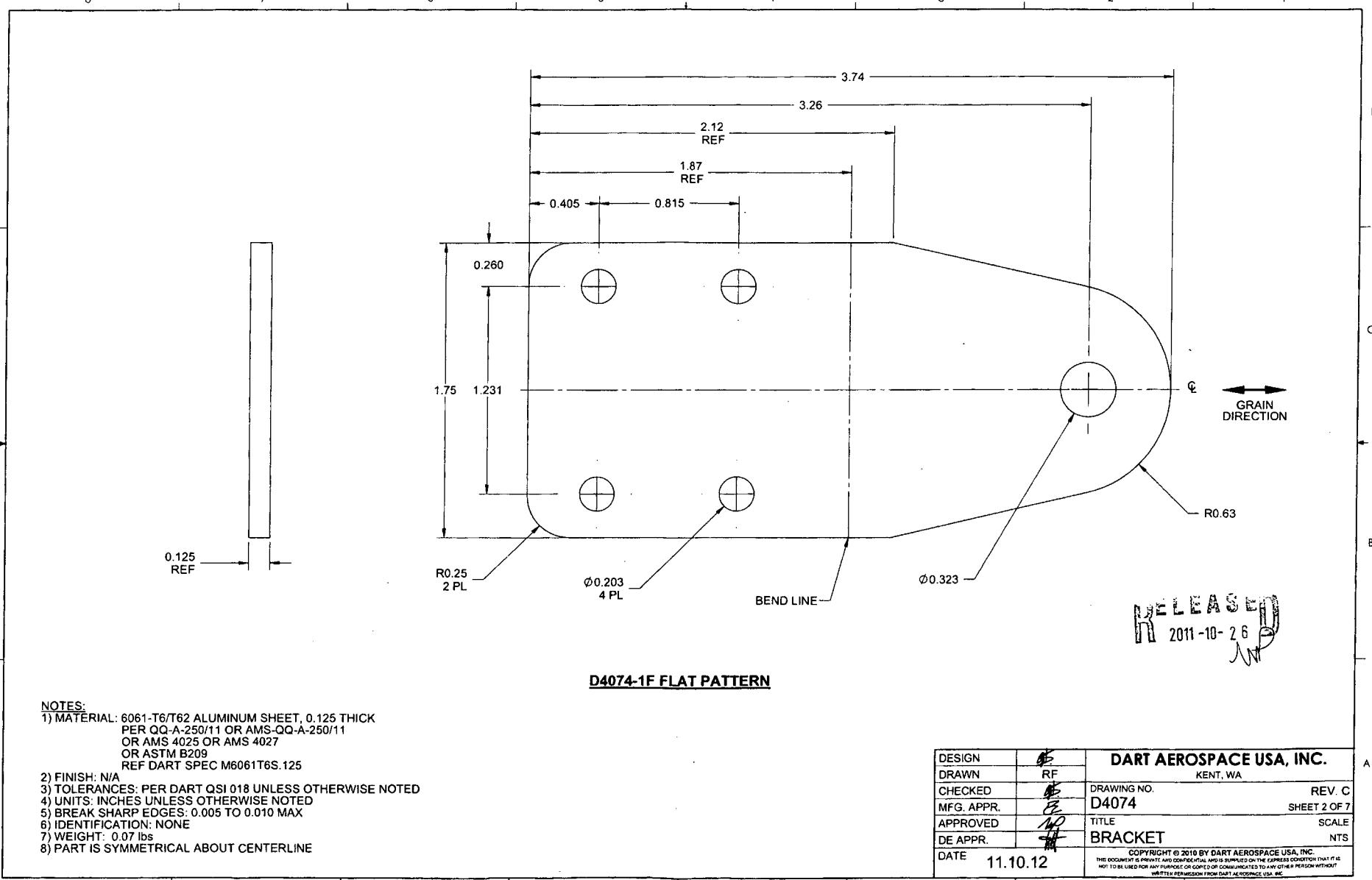
27

Measured by:	<i>Ak</i>	Audited by:	<i>27</i> 9-89	Preliminary Approval:	
Date:	<i>13.10.05</i>	Date:	<i>13.10.7</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ	
B	11.07.26	Dwg Rev updated	KJ	
C	12.03.08	Dwg Rev updated	KJ	 



C	MODIFY -7 STRIKER PLATE, SHEET 6 AND 7	HS	11.10.12
B	Ø0.173 WAS Ø0.129 (ZN B3-4); 1.28 WAS 0.90 (ZN C4-6); 1.93 WAS 1.55 (ZN C2-7); 2.10 WAS 1.72 (ZN C1-7)	RF	11.03.07
A	NEW ISSUE	HS	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AS</i>	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>AS</i>	REV. C	
MFG. APPR.	<i>EZ</i>	DRAWING NO. D4074	
APPROVED	<i>AS</i>	SHEET 1 OF 7	
DE APPR.	<i>AS</i>	TITLE BRACKET	SCALE NTS
DATE	11.10.12	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA
DRAWN		DRAWING NO.
CHECKED		REV. C
MFG. APPR.		D4074
APPROVED		SHEET 2 OF 7
DE APPR.		TITLE
		SCALE
		NTS
		DATE 11.10.12

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